

Date: Thursday, 15/01/2009 11:13:11 AM
User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BEARPAW KIT (19"X16")
Job Number :	44774		
Estimate Number :	12664		
P.O. Number :		Part Number :	D206559011
This Issue :	15/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2435 REVE1
First Issue :	1/1	Project Number :	N/A
Previous Run :	42974	Drawing Revision :	E1
	Type :	Material :	
	MACHINED PARTS	Due Date :	10/02/2009
Written By :		Qty:	6 Unit Each
Checked & Approved By :	<u>JUL 09.01.15</u>		
Comment :	Est Rev:C 04.02.17 Blank size changed KJ/JLM Est Rev:D 07-01-02 Was K10007 JLM Est Rev:E 08-05-05 up a chg DD verified by:EC Est Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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C269/02/12



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPPD206-559-011 CHG006

8 09/02/12

2.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: MFG ENGINEERING

Program Batch Number

09-02-02

3.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 3.4083 sf(s)/Unit Total : 20.4498 sf(s)

Material: Black UHMW 1"
(MUHMWB10)

Batch: 110721 B 9-2-7

(12) PIECES

4.0	WATER JET	FLOW WATER JET
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B 9-2-7



Comment: FLOW WATER JET

Cut Blank as per File D2435

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435

3-Deburr

SL 09/02/11

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL 09/02/11

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

DJP 09/02/11

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

9.0

D2182B

Rubber Cushion



Comment: Qty.: 1.6660 f(s)/Unit Total : 9.9960 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B050 Rubber Cushion

42737

SS 09/02/12 (K6)

10.0

D2274

Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block

2 D2435(ref only) Bearpaw

43538

SS 09/02/12 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2438

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2438

Clamp

AB41428

SS 09/02/12 (x6)

12.0

D2529

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529

Washer

42408

SS 09/02/12 (x6)

13.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A

Bolt

M109148

SS 09/02/12 (x6)

14.0

AN417A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Batch:

M109061

SS 09/02/12 (x6)

15.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

M116523

SS 09/02/12 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Part Number: D206559011

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

M109282

SS 09/02/12 (a)

17.0

QS200M44S

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 QS200M44S

Clamp

M110398

1 Paperwork package

SS 09/02/12 (b)

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 09/02/12 (c)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-011

Location: Rev B

9/2/12

SP

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17 (d)

Job Completion



W 09.02.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

44774

DART AEROSPACE LTD		Work Order: 44774
Description: Bearpaw		Part Number: D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓			
B	5.500	+/-0.030	5.505	✓			
C	0.200	+/-0.030	.201	✓			
D	R0.250	+/-0.030	1.250	✓			
E	0.250	+/-0.010	.249	✓			
F	0.625	+/-0.030	.626	✓			
G	0.25 x 45°	+/-0.030	2.78 x 45°	✓			
H	0.375	+/-0.010	.375	✓			
I	19.000	+/-0.030	19.00	✓			
J	0.950	+0.030/-0.010	.952	✓			
K	Ø0.260	+0.005/-0.000	.260	✓			
L	Ø0.930	+/-0.030	.925	✓			
M	0.30	+0.030/-0.000	.310	✓			
N	0.375	+/-0.030	.377	✓			
O	7.375	+/-0.030	7.376	✓			
P	4.250	+/-0.010	4.250	✓			
Q	2.000	+/-0.030	2.020	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.750	✓			

Measured by: J.L.	Audited by: DIP	Prototype Approval: N/A
Date: 09/02/11	Date: 09/02/11	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	✓



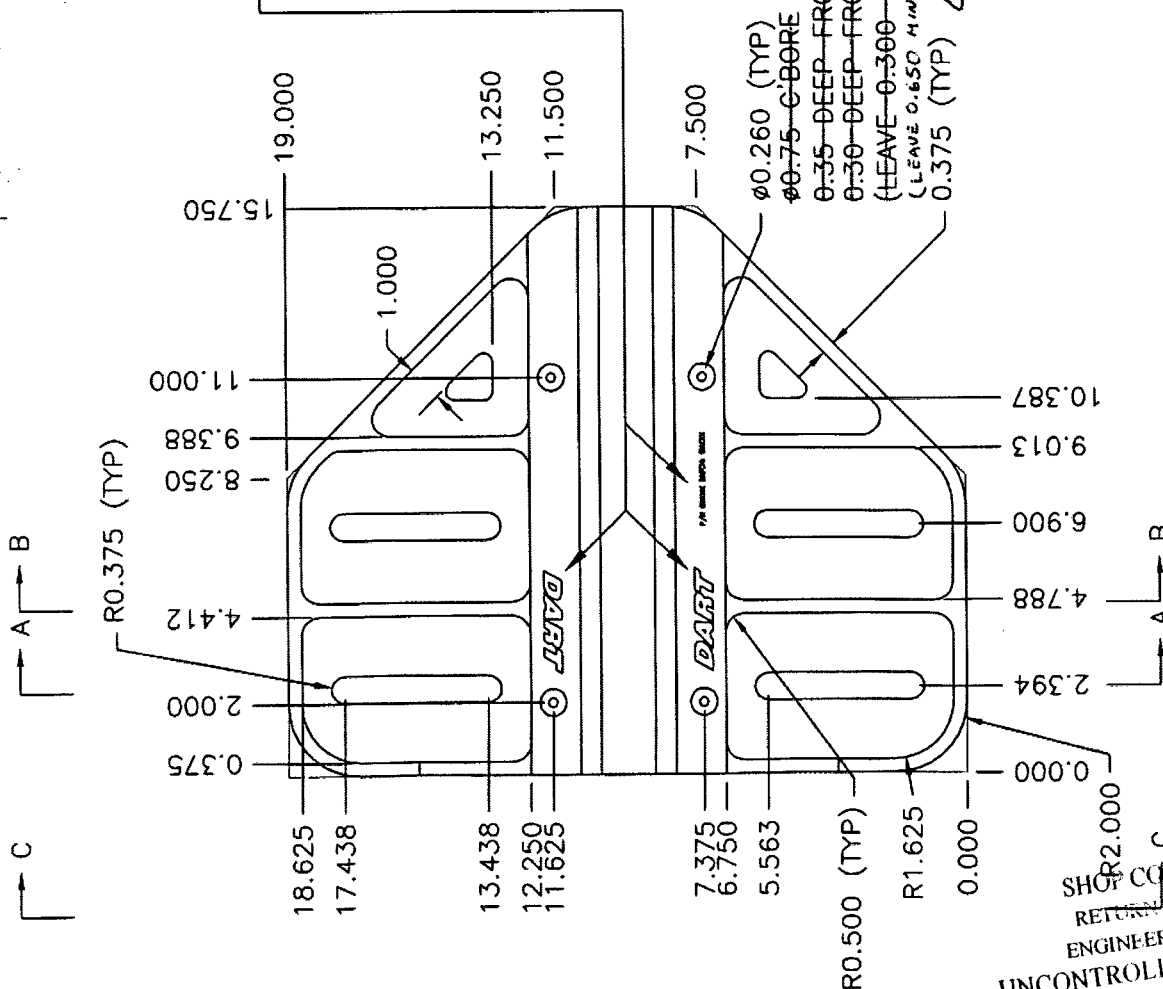
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED WY	APPROVED QS	DRAWING NO. D2435	REV. E SHEET 1 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:5
A	96.01.24	NEW ISSUE	
B	96.03.26	CHANGE BORE AND C'BORE DEPTH	
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED	
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)	
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50	

EFFECTIVE DEOS

9143	

RELEASED
98.06.17 KE

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)



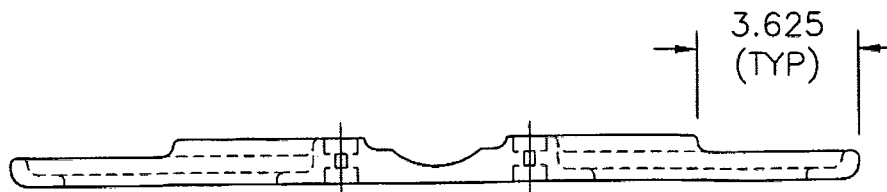
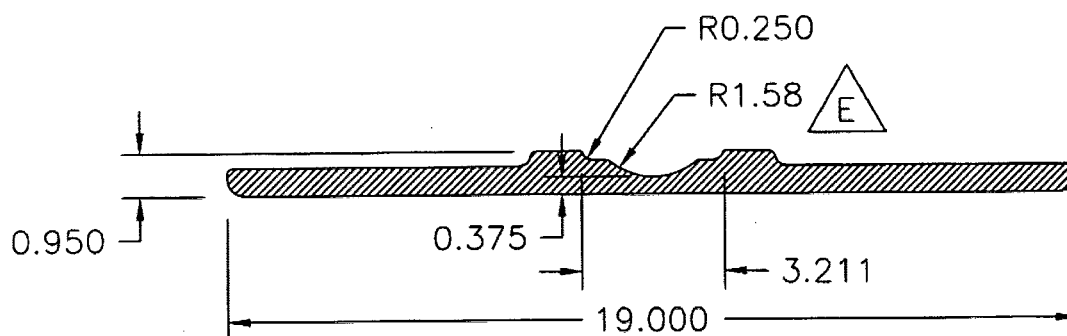
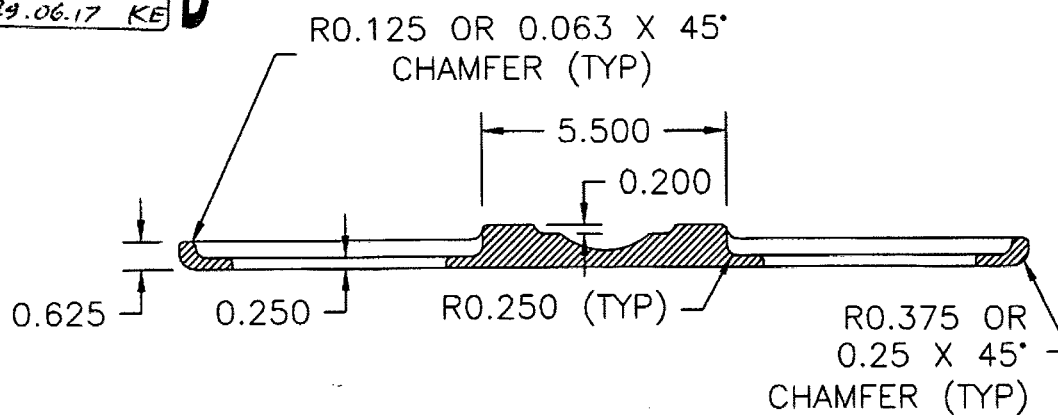
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 14174



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DB	APPROVED JS	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE



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WORK ORDER
NO. 149779